

Date: Monday, 09/06/2008 12:36:12 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEB
Job Number :	39739		
Estimate Number :	10498		
P.O. Number :		Part Number :	D2739
This Issue :	09/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2739 REV D
First Issue :	//	Project Number :	N/A
Previous Run :	39672	Drawing Revision :	D
Written By :		Material :	
Checked & Approved By :	JUL 08.10.09	Due Date :	16/06/2008
Comment :	Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM Est Rev: E 07-07-28 As per Rev D JLM Verified By:		

Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Extrusion 'I Beam' thin
 Pick:
 Qty Part Number Description Batch
 1 D2600-5 Web B-29985

AWM
8-6-9

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
 1-Cut D2600-5 to length as per Dwg D2739.
 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
 3-Use uni-bit to open holes to finish size as per Dwg D2739.
 4-Bevel Fwd end of extrusion and Deburr holes and ends.
 5-Dburr

AWM
8-6-9

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BF 8-6-10

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4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SL8-6-10

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(4) M 8-6-10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: L6

SL8-6-10

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

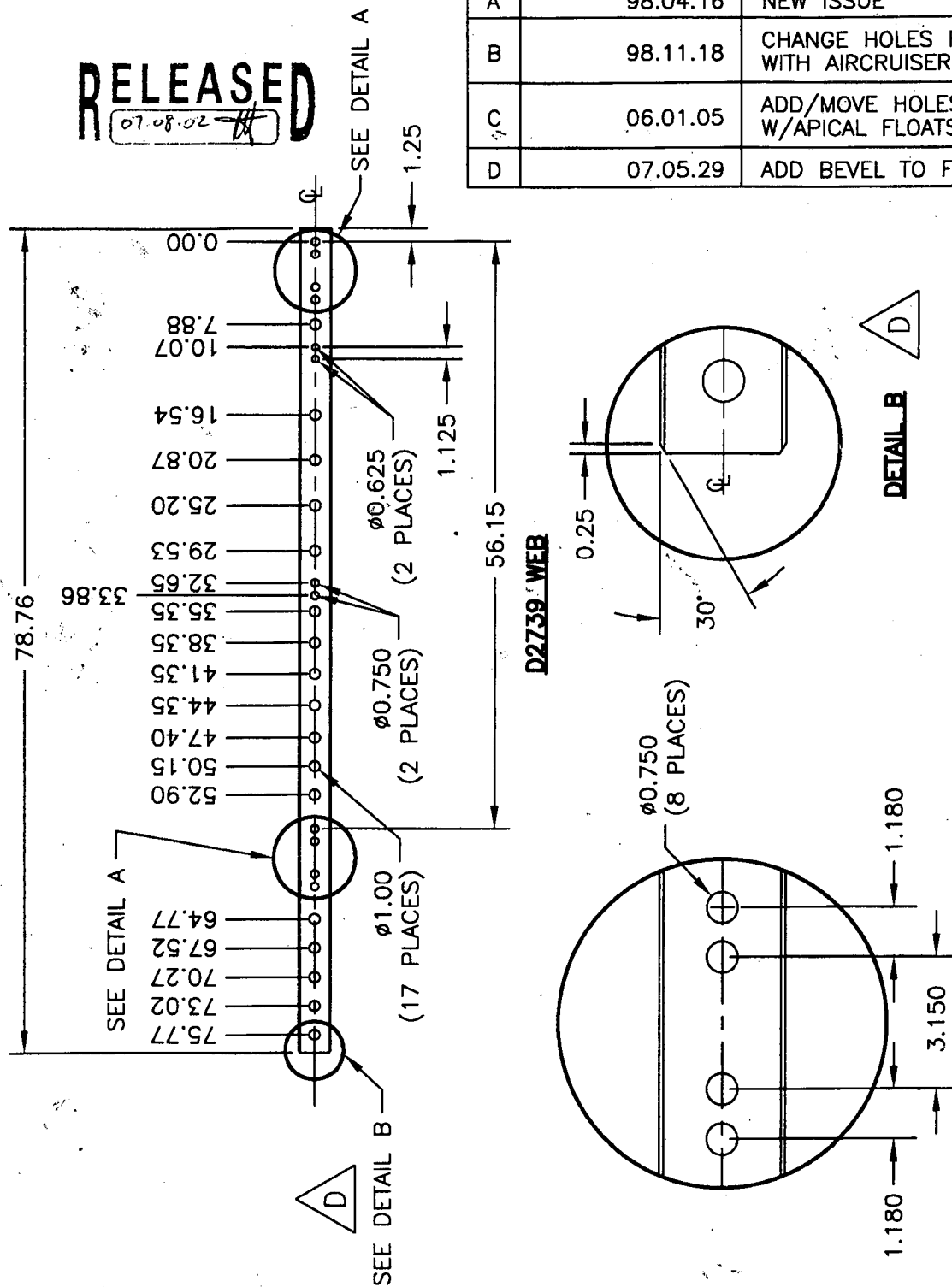
Job Completion



SL 08-06-10

RELEASED
07-08-02

DESIGN PH		DRAWN BY CB		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH		APPROVED [Signature]		DRAWING NO. D2739 REV. D SHEET 1 OF 1	
DATE 07.05.29		TITLE WEB		SCALE 1:15	
A	98.04.16	NEW ISSUE			
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS			
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS			
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B			



DETAIL A

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT C-₁

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ENGINEERING

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WITHOUT NOTICE
WORK ORDER
NO. 39739

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